<b>Work Order</b> Tuesday, February											Page 1
Revision ID: Item Name: P	03255-2 ranel /23/2011 /9/2011	Start Qty: 2.00 Req'd Qty: 2.00		Accept	Cust Item I			s	etup Star Stop	1 18011181 81	111 111 111 1111 111 111 111 1111
		n: MF	Date: 1-023			ite:		F	kun Stai Sto <sub>l</sub>		
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #		Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D3255	Revi Rev	B .	1	0.00				,			
Waterjet FLOW CNC Waterjet		FLOW WATER JET  Memo  1-Cut as per  Deburr if n	er Dwg D3255 □Dwg Re ecessary	0.00	<u>R</u> [72-			B	11-9-93	i Q	t)
QC Quality Control		QC2- Inspect parts off i	nachine FAI/FAIB	0.00	·		_	BI	1-7-73	· -	
120 		QC8- Inspect parts - see	cond check	0.00 Sw	orluf		_	(4L)	9		

Quality Control

Dart Aerospace Li
-------------------

	- Pass								•			
W/O:			WORK ORDER CHANGES									
DATE	STEP	PRC	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
						····						
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	A:	Date: _				
Resolution:			Disposition	on:	QA: N/C C	losed:		Date: _				
NCR:		1	WORK ORD	DER NON-CONFORMA	NCE (NC	₹)						
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval			
DAIL	JILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	Section C		Chief Eng	QC Inspector			
									-			

Page 2

Tuesday, February 22, 2011 11:06:10 AM

Item ID:

D3255-2

**Revision ID:** Item Name:

Panel

**Start Date:** 

2/23/2011

Required Date: 3/9/2011

Start Qty: 2.00 Req'd Qty: 2.00



Accept

Setup Start



Stop

**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

QC:

Process Plan:

Memo

Memo

Memo

Date: \_\_\_\_\_

Tooling:

SPC (Y/N):

Date:

Date:

Tool # Plan

Code

Run

Reject

Qty

Start



Stop

Sequence ID/ **Work Center ID** 

130

Brake NC

Brake NC

Operation Description

NC BRAKE

Set Up/ **Run Hours** 

Date:

0.00

Sp 11/03/02

Accept

Qty

Reject Insp. Number

Stamp

140

Quality Control

QC5- Inspect part completeness to step on W/O

Form as per Dwg D3255

150

Packaging

Packaging

Identify as per dwg & Stock Location: W/4

0.00

0.00

a 11-3-2



## **Dart Aerospace Ltd**

Dait Ac	iospace L	-tu						,	
N/O:		······································	WO	RK ORDER CHANGI	ES		· <del>-</del> · ··· · · · · · · · · · · · · · · · ·		
DATE	STEP	PRO	OCEDURE CHAN	IGE	Ву	Date Q	ty Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #: Fault Category:			NCR: Yes No DQA: Date:				
	Res	solution:	Disposition	l:	_ QA: N/C Cld	sed:	Date: _		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
		Description of NC		Corrective Action Section	on B	Verification	on Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	8 7	QC Inspector	
							1		
				-					

### Work Order ID 66575

Page 3

Tuesday, February 22, 2011 11:06:10 AM

Item ID:

D3255-2

**Revision ID:** 

Item Name: Panel

**Start Date:** 2/23/2011 Required Date: 3/9/2011

Req'd Qty: 2.00

Operation

Description

Start Qty: 2.00



Accept

Setup Start

Stop

Start

Stop

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Date: \_\_\_\_\_

SPC (Y/N):

**Tooling:** 

Set Up/

Run Hours

Tool ID

Date:

Date:

Tool # Plan Code

Reject Accept Qty Qty

Run

Reject

Insp. Number / Stamp

160

Sequence ID/

**Work Center ID** 

Quality Control

Memo

QC21- Final Inspection - Work Order Release

0.00

0.00

Dart .	Aeros	pace	Ltd
--------	-------	------	-----

	···					·		· · · · · · · · · · · · · · · · · · ·			
W/O:			WC	ORK ORDER CHANG	GES						
DATE	STEP	PRO	DCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							1				
Part No	:	PAR #:	Fault Category: NO								
Resolution:			Dispositio	n:	QA: N/C (	Closed:		Date: _			
NCR:		•	WORK ORD	ER NON-CONFORM	ANCE (NC	R)					
DATE	CTED	Description of NC			ction B	Verifi	cation	Approval Chief Eng	Approval		
DAIE	SIEP	STEP Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign Dat	&   Sec	tion C		QC Inspector		
									·		
<del></del> -											
			74								

# **Picklist Print**

Tuesday, February 22, 2011 11:06:05 AM

Work Order ID: 66575

Parent Item: D3255-2

Parent Item Name: Panel



Start Date: 2/23/2011

Required Date: 3/9/2011

Page 1

Start Qty: 2.00

Required Oty: 2.00

Comments:

IPP Rev:A New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA		Purchased	No			100	sf	61.2896	1.484	3.124211			
										iRil.	-8-93		

304/316 .032 Sheet

<b>Location</b>	Loc Qty	Loc Code
MAT20	61.2896	
109023	30.2896	
109057	31	

109033

Dart Ae	rospace	Ltd
---------	---------	-----

	. Jopass											
W/O:			W	ORK ORDER CHANG	SES							
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	,	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Category: NCR: Yes No DQA						A: Date:			
		esolution:										
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)						
DATE	STEP	Description of NC	Corrective Action Section B			Verification		cation	Approval	Approval		
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Sect	ion C	Chief Eng	QC Inspector		
								•				
										*		

DART AEROSPACE LTD	Work Order:	66575
Description: Access Panel Assembly	Part Number:	D3255-2
Inspection Dwg: D3255 Rev: B		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

	X	First Artic	cle	Prote	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	-103	7		U 1802	
15.171	+/-0.010	15171	7		4	
10.032	+/-0.010	650,01	<b>1</b> 2-		7 1301	
6.902	+/-0.010	6,909	>		7	
18.456	+/-0.010	18.456	1		7	,
11.432	+/-0.010	11,440	يز		7	
2.261	+/-0.010	2.261	7		٧	
2.363	+/-0.010	2.355	<b>)</b>		V	
2.363	+/-0.010	2.354.	,		V	
1.183	+/-0.010	1.184	7		V	
0.250	+/-0.010	920	2		Ů	
0.250	+/-0.010	. 549	<b>ک</b>		V	
2.261	+/-0.010	3751	8		V	-
		- · · · · · · · · · · · · · · · · · · ·				

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 11-3-33	Date: Worl24	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	08.05.06	New Issue	KJ/DD OK	N
				-

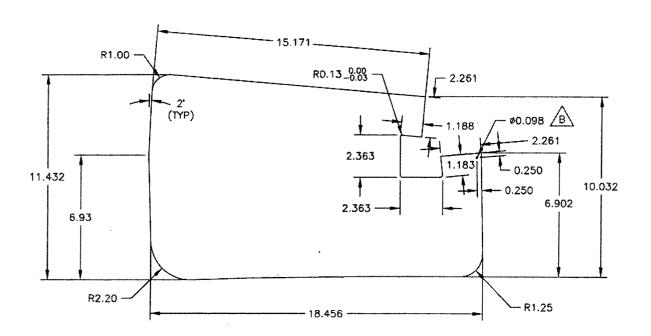
Dart A	erospa	ce Ltd
--------	--------	--------

	•								
W/O:			· W	ORK ORDER CHANGE	S				
DATE	STEP	PROC	EDURE CH	ANGE	Ву	By Date Qty Appro			Approval QC Inspector
			. `					. 4: 9	
Part No	•	PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
Resolution:			Disposition: QA: N/C Closed: Date:						
NCR:		W	ORK ORE	DER NON-CONFORMA	NCE (NCR	)			
DATE		Description of NC	Corrective Action Section B			Verification		Approval	Approval
DAIE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
				*					:
			1						
							·		
				•					
				•					



DESIGN F	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAI	
CHECKED	APPROVED	DRAWING NO.	REV. B
P	1 #	D3255	SHEET 3 OF 4
DATE	······································	TITLE	SCALE
04.12.06		ACCESS PANEL ASSEMBLY	1:5







#### D3255-1/-2 FLAT PATTERN

### D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
  2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

Copyright @ 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

## **Dart Aerospace Ltd**

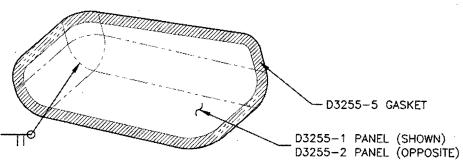
Dail Aci	Uspace	Liu							, , ,		
W/O:			W	ORK ORDER CHANG	ES		. ,				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву			Approval Chief Eng / Prod Mgr	Approval QC Inspector		
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No <b>DQ</b>	A:	Date:			
Resolution:			Disposition	Disposition: Q			QA: N/C Closed: Date:				
NCR:		,	WORK ORD	ER NON-CONFORMA	ANCE (NC	R)					
		Description of NC	Corrective Action		Section B		cation	Annewal	Approval		
DATE	STEP	P Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign Date	&   Sec	Verification Section C	Approval Chief Eng	QC Inspector		
								,			
		÷									



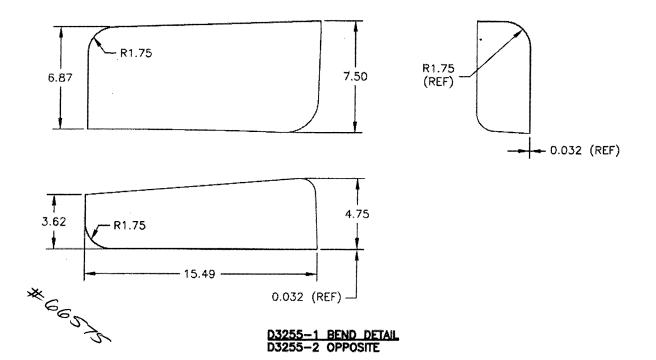
DESIG	14	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECK	ED , 🕜	APPROVED	DRAWING NO. RE	V. B
	W	<del>-    -  </del>	D3255 SHEET 1 C	)F 4
DATE			TITLE SO	CALE
04.1	2.06		ACCESS PANEL ASSEMBLY	1:6
Α		04.01.27	NEW ISSUE	
В		04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	inghangaranan (saya sa



WELD D3255-3



#### D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



- D3255-041/-042 NOTES:
  1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

# **Dart Aerospace Ltd**

	Johaso								, , ,
W/O:			WC	RK ORDER CHANG	ES				,
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
					,				
· ,· - ,.·									
					ļ.				
· · · · · · · · · · · · · · · · · · ·									
Part No: PAR #:		PAR #:	Fault Category: NC			s No Do	Date:		
						Date:			
NCR:		'	WORK ORDI	ER NON-CONFORMA	NCE (NC	CR)			
DATE	STEP Description of NC Section A	Description of NC	Corrective Action Section			Veri	Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE		Initial Chief Eng	Action Description Chief Eng	Sigi Da	1&i <sub>Se</sub>				
					ļ				
								į	,